

**Work Order ID 81610****\*81610\***

Page 1

March-16-12 8:37:08 AM

Item ID: D058-677-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step LH

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/03/16

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D2943

RevC

100

0.00

**\*100\***

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPPD058-677-011

CHG 002

5/12/07/10

110

0.00

**\*110\***

Large Fab

Memo

0.00

Large Fab

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and mounting plates as per Dwg D2943

A/R AL ROD

Batch: 120854

4-Grind end cap welds flush as per dwg D2943

2ØAe12.05.2312.06.132ØAe12.06.20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 81610****\*81610\***

Page 2

Item ID: D058-677-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step LH

Stop **\*NS2\***

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

2 0 SEP 26/26

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

8/26/2672

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

2 7/6 126.28

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**\*81610\***

Page 3

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 16/03/2012    **Start Qty:** 2.00

\*2\*

**Cust Item ID:**

**Required Date: 30/03/2012      Req'd Qty: 2.00**

\*2\*

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

[illegible]

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 81610

March-16-12 8:37:08 AM

**\*81610\***

Page 4

Item ID: D058-677-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step LH

Stop **\*NS2\***

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

180 QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC Memo

0.00

Quality Control

190

0.00

**\*190\***

HandFinish Memo

0.00

Hand Finishing

1-Pressure wash as per QSI 005  
2-Touch up Chemical Conversion Coat as per QSI 005 4.1

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*200\***

Powdercoat Memo

0.00

Powder Coating

M121841

Start Time: 8:30  
Temp: 320°F  
Finish Time: 9:00

2 246 12.73

2X

M/L  
12/07/04

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Work Order ID 81610

March-16-12 8:37:08 AM

**\*81610\***

Page 5

Item ID: D058-677-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step LH

Stop

**\*NS2\***

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Wing Walk as per dwg QSI005 4.4 Batch 121613

0.00

**\*210\***

HandFinish

Memo

0.00

Hand Finishing

2 ~~2~~ ~~2P~~ 12/07/11

220

QC3- Inspect Part Finish

0.00

**\*220\***

QC

Memo

0.00

Quality Control

12/07/11

230

QC5- Inspect part completeness to step on W/O

0.00

**\*230\***

QC

Memo

0.00

Quality Control

S 12/07/11

CK 12/7/11

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 81610

**\*81610\***

Page 6

March-16-12 8:37:08 AM

Item ID: D058-677-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Heli-Access-Step LH

Stop

**\*NS2\***

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

Pick Kit

0.00

**\*240\***

Packaging

Memo

0.00

Packaging

2 12/07/06 JB

241

QC4- 100% Inspect kits for completeness

0.00

**\*241\***

QC

Memo

0.00

Quality Control

8/12/07/10

(+2)

250

0.00

**\*250\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D058-677-011

Location:

PPP Rev: C

2x 8p 12-7-10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 81610**

March-16-12 8:37:08 AM

**\*81610\***

Page 7

Item ID: D058-677-011

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Heli-Access-Step LH

Stop **\*NS2\***

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260

QC21- Final Inspection - Work Order Release

0.00

**\*260\***

QC

Memo

0.00

Quality Control

OK 12/7/11 3

12-07-11

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

March-16-12 8:37:11 AM

Page 1

Work Order ID: 81610

\*81610\*

Parent Item: D058-677-011

\*D058-677-011\*

Parent Item Name: Heli-Access-Step LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B01.04.11Combined with D2943-041EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2622-120C

Manufactured

No

110

Each

68.7300

1

2

\*D2622-120C\*

Step Extrusion

\*\*

B81507 (2) Ac 12.05.23

Location

Loc Qty

Loc Code

HALL

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA013

52.36

75781

2.4

77612

49.96

D2734

Manufactured

No

110

Each

109.0000

2

4

\*D2734\*

Step End Plate

\*\*

12.07.03

Location

Loc Qty

Loc Code

WA

B83322 = 2

109

76985

49

80682

60

B84563 = 2

110

Each

11.0000

2

4

D3458-1

Manufactured

No

\*D3458-1\*

Step Mounting Plate

\*\*

12.06.14

Location

Loc Qty

Loc Code

WA002

B82117

10

75609

10

WA018

1

63075

1

4

672 - 01

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

March-16-12 8:37:11 AM

Page 2

Work Order ID: 81610

\*81610\*

Parent Item: D058-677-011

\*D058-677-011\*

Parent Item Name: Heli-Access-Step LH

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3458-3 Manufactured No

110 Each

21.0000 2 4

\*D3458-3\*

Step Mounting Plate

\*\*

12.06.14

Location

Loc Qty

Loc Code

WA002 382116

21

75610

21

D2731-3 Manufactured No

240 Each

80.0000

2 4

D2731-3

\*D2731-3\*

Mounting Lug

\*\*

JB

Location

Loc Qty

Loc Code

ST469

80

73417

80

D3394-043 Manufactured No

240 Each

48.0000

2 4

D3394-043

\*D3394-043\*

Lug Assembly

\*\*

73417

80217 JB

Location

Loc Qty

Loc Code

ST479

48

69180

12

71082

1

72520

1

78921

34

D2732-030 Manufactured No

240 Each

9.0000

8 16

D2732-030

\*D2732-030\*

Rubber Cushion

\*\*

83560 JB

12/07/06

Location

Loc Qty

Loc Code

ST402

9

76850

3

78144

6

March-16-12 8:37:12 AM

Shop Packet Print

Page 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

March-16-12 8:37:12 AM

Page 3

Work Order ID: 81610

Parent Item: D058-677-011

Parent Item Name: Heli-Access-Step LH

\*81610\*

\*D058-677-011\*

4

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

D3394-041

Manufactured No

240 Each

40.0000



4

\*\*

JB

\*D3394-041\*

Lug Assembly

Location

Loc Qty

Loc Code

ST479

40

74505

40

240 Each

152.0000



16

\*\*

74505

12x121349 JB

4x122141

AN4-14A

\*AN4-14A\*

Bolt

Purchased No

Location

Loc Qty

Loc Code

ST357

152

118451

5

119798

84

120187

13

120769

50

240 Each

18.0000



4

\*\*

78922 JB

12/07/06

D2731-7

\*D2731-7\*

Mounting Lug

Manufactured No

Location

Loc Qty

Loc Code

ST

-50

ST468A

18

69177

12

71083

2

71860

4

ST469

50

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

March-16-12 8:37:12 AM

Page 4

Work Order ID: 81610

Parent Item: D058-677-011

Parent Item Name: Heli-Access-Step LH

\*81610\*

\*D058-677-011\*

Start Date: 16/03/2012

Required Date: 30/03/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-15A

Purchased

No

240

Each

375.0000



8

✓

\*AN4-15A\*

Bolt

\*\*

122141 JB

## Location

## Loc Qty

## Loc Code

GA

100

120449

100

ST358

275

118706

15

120187

60

120422

200

AN960JD416

NAS1149D04631

Purchased

No

240

Each

14.0000



24

✓

\*AN960JD416\*

Washer

\*\*

121912 JB

## Location

## Loc Qty

## Loc Code

ST351

14

116289

14

MS21042L4

Purchased

No

240

Each

5,527.000



24

✓

\*MS21042L4\*

Nut

\*\*

121444 JB 12/07/06

## Location

## Loc Qty

## Loc Code

ST300

5527

117441

51

117601

157

118451

133

119017

200

119075

2986

121011

2000

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

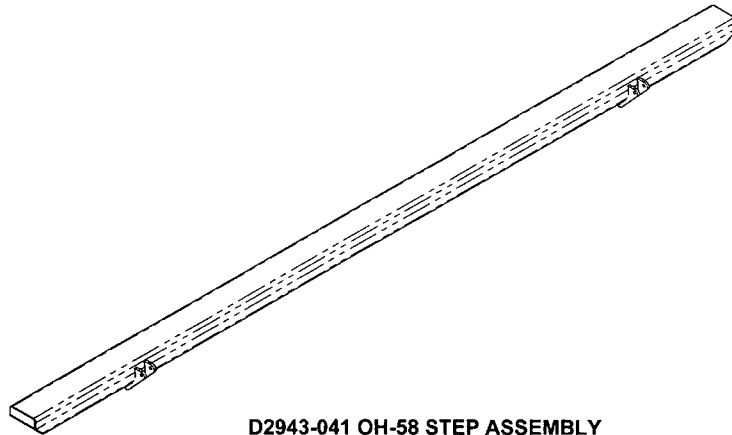
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

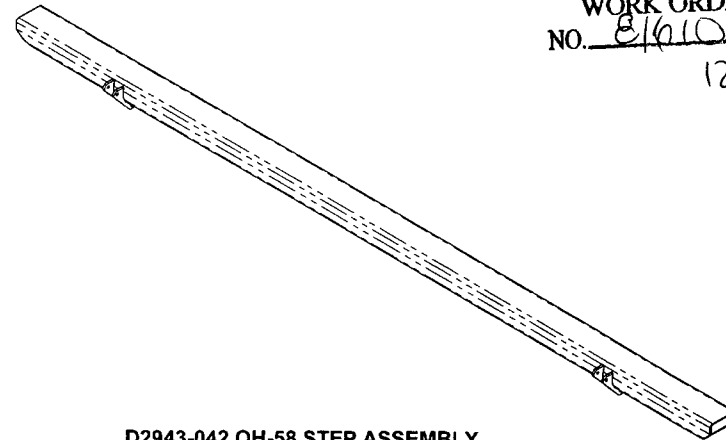
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

| ITEM No. | QTY. -041 | QTY. -042 | PART NUMBER | DESCRIPTION             |
|----------|-----------|-----------|-------------|-------------------------|
| 1        | X         |           | D2943-041   | OH-58 STEP ASSEMBLY, LH |
| 2        |           | X         | D2943-042   | OH-58 STEP ASSEMBLY, RH |
| 7        | 1         | 1         | D2943-1     | STEP                    |
| 11       | 2         | 2         | D2734       | END PLATE               |
| 12       | 2         | 2         | D3458-1     | STEP MOUNTING PLATE     |
| 13       | 2         | 2         | D3458-3     | STEP MOUNTING PLATE     |



**D2943-041 OH-58 STEP ASSEMBLY**



**D2943-042 OH-58 STEP ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 81010 MJS  
12/03/16

**RELEASED**  
09/06/25 MJS

**D2943-041/-042 NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.31 lbs
- 8) WELD PER QSI 004

|            |  |   |              |
|------------|--|---|--------------|
| C          | REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS ATTACHMENT CHANGED FROM SINGLE LUG TO DOUBLE LUG D2725 REPLACED BY ITEMS 12 & 13 REASON: SEE PAR 152 ADDED ITEM 7, D2622-082 MOVED FROM P/L TO NOTES ON SHEET 3. | AJS   | 08.11.17     |
| B          | UPDATED FINISHING NOTE   | PH  | 05.11.14     |
| A          | NEW ISSUE  | RF  | 99.11.19     |
| REV.       | DESCRIPTION  | BY  | DATE         |
| DESIGN     | RF   | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA   |              |
| DRAWN      | AJS  |   |              |
| CHECKED    |  | DRAWING NO  | REV. C       |
| MFG. APPR. |  | D2943   | SHEET 1 OF 3 |
| APPROVED   |  | TITLE   | SCALE        |
| DE APPR.   |  | OH-58 STEP ASSEMBLY   | NTS          |
| DATE       | 08.11.17   | COPYRIGHT © 1999 BY DART AEROSPACE USA, INC.<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

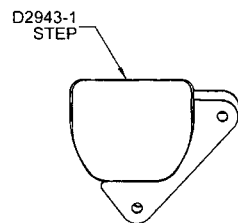
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





D2734  
END PLATE  
2 PL

11.43  
REF

APPLY BLACK ANTI-SKID PAINT  
ON TOP SURFACE TO BOTTOM  
OF TOP RADIUS

11.32  
(FROM UNCAPPED END)

TYP

82°  
TYP

D3458-3  
STEP LUG  
2 PL

D3458-1  
STEP LUG  
2 PL

0.450  
TYP

0.900  
TYP

### D2943-041 OH-58 STEP ASSEMBLY

81610

11.32  
(FROM UNCAPPED END)

57.06

11.43  
REF

APPLY BLACK ANTI-SKID PAINT  
ON TOP SURFACE TO BOTTOM  
OF TOP RADIUS

D3458-1  
STEP LUG

D3458-3  
STEP LUG

0.450  
TYP

0.900  
TYP

82°  
TYP

TYP

D2734  
END PLATE  
TYP

D2943-1  
STEP

### D2943-042 OH-58 STEP ASSEMBLY

RELEASED  
9/25/14

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | RF       | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA   |              |
| DRAWN      | AJS      |   |              |
| CHECKED    |          | DRAWING NO.   | REV. C       |
| MFG. APPR. |          | D2943   | SHEET 2 OF 3 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | OH-58 STEP ASSEMBLY   | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

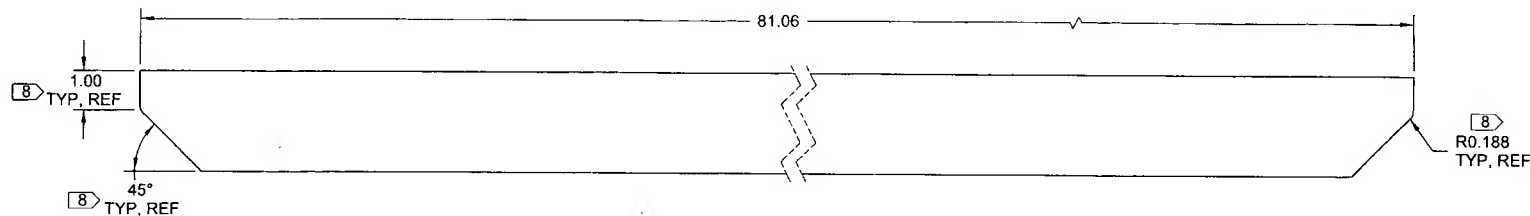
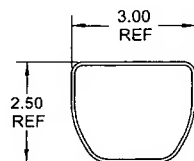
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

01610



**D2943-1 STEP**

**D2943-1 NOTES:**

- 1) MATERIAL: MAKE FROM D2622-082 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.93 lbs
- 8) SHAPE TO FIT D2734 END CAP

**RELEASED**  
01/06/25

|            |          |   |                        |
|------------|----------|---|------------------------|
| DESIGN     | RF       | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA   |                        |
| DRAWN      | AJS      |   |                        |
| CHECKED    |          | DRAWING NO.<br><b>D2943</b>   | REV. C<br>SHEET 3 OF 3 |
| MFG. APPR. |          | TITLE   | SCALE                  |
| APPROVED   | NN       | <b>OH-58 STEP ASSEMBLY</b>  |                        |
| DE APPR.   |          | NTS   |                        |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

## 4.0 PARTS LIST:

| Qty<br>-011 | Qty<br>-012 | Qty<br>-013 | Qty<br>-014 | Part Number  | Description                     |
|-------------|-------------|-------------|-------------|--------------|---------------------------------|
| X           |             |             |             | D058-677-011 | HELI-ACCESS-STEP™, LH           |
|             | X           |             |             | D058-677-012 | HELI-ACCESS-STEP™, RH           |
|             |             | X           |             | D058-677-013 | HELI-ACCESS-STEP™, LH           |
|             |             |             | X           | D058-677-014 | HELI-ACCESS-STEP™, RH           |
| 1           |             | 1           |             | D2943-041    | STEP ASSEMBLY LH                |
|             | 1           |             | 1           | D2943-042    | STEP ASSEMBLY RH                |
|             |             | 2           | 2           | D3394-045    | MOUNTING LUG (REPLACES D2230-1) |
|             |             | 2           | 2           | D2230-3      | MOUNTING LUG                    |
| / 2         | 2           |             |             | D3394-041    | MOUNTING LUG (REPLACES D2731-1) |
| / 2         | 2           |             |             | D2731-3      | MOUNTING LUG                    |
| / 2         | 2           | 2           | 2           | D3394-043    | MOUNTING LUG (REPLACES D2731-5) |
| / 2         | 2           | 2           | 2           | D2731-7      | MOUNTING LUG                    |
| / 8         | 8           | 8           | 8           | D2732-030    | RUBBER CUSHION                  |
| / 8         | 8           | 4           | 4           | AN4-14A      | BOLT                            |
| / 4         | 4           | 4           | 4           | AN4-15A      | BOLT                            |
|             |             | 4           | 4           | AN4-16A      | BOLT                            |
| / 12        | 12          | 12          | 12          | AN960JD416   | WASHER                          |
| / 12        | 12          | 12          | 12          | MS21042L4    | NUT (OR MS21042-4)              |

## 5.0 WEIGHT AND BALANCE:

| Installation                               | Weight             | LATERAL               |                              | LONGITUDINAL        |                          |
|--|--------------------|-----------------------|------------------------------|---------------------|--------------------------|
|  |                    | Arm                   | Moment                       | Arm                 | Moment                   |
| D058-677-011/-013<br>HELI-ACCESS-STEP™, LH | 8.15 lb<br>3.70 Kg | - 36.5 in<br>- 0.93 m | - 297.5 in-lb<br>- 3.30 m-kg | 100.44 in<br>2.55 m | 818.6 in-lb<br>9.44 m-kg |
| D058-677-012/-014<br>HELI-ACCESS-STEP™, RH | 8.15 lb<br>3.70 Kg | +36.5 in<br>+0.93 m   | +297.5 in-lb<br>+3.30 m-kg   | 100.44 in<br>2.55 m | 818.6 in-lb<br>9.44 m-kg |

# Work Order ID 81610

March-16-12 8:37:08 AM

**\*81610\***

Page 1

Item ID: D058-677-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step LH

Start Date: 16/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 30/03/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/03/12* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|       |      |
|-------|------|
| D2943 | RevC |
|-------|------|

|     |      |
|-----|------|
| 100 | 0.00 |
|-----|------|

**\*100\***

|    |      |
|----|------|
| DC | 0.00 |
|----|------|

Document Control Memo Photocopy bluefile & type labels per PPPD058-677-011 CHG 002

*CL 12/07/04*

|     |      |
|-----|------|
| 110 | 0.00 |
|-----|------|

**\*110\***

|           |      |
|-----------|------|
| Large Fab | 0.00 |
|-----------|------|

Large Fab Memo 1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap and mounting plates as per Dwg D2943  
A/R AL ROD Batch: *120854*

4-Grind end cap welds flush as per dwg D2943

*2*

*Ø*

*Ac 12.05.23  
11/12.06.13*

*2*

*Ø*

*Ac 12.06.20*